

Work Order ID 82005

82005

Page 1

March-21-12 3:43:16 PM

Item ID: D350-636-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube LH

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/21

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

JB Sizkulzo

for MLJ 12-4-20

382005

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82005***82005***

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N9000040100Setup Start ***NS1***

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1

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Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail C to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

B 12/04/02

Dart Aerospace Ltd

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Required Date: 04/04/2012 Req'd Qty: 1.00

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Reference:

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QC: Date: SPC (Y/N): Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *m120164*

BE 12/4/02

12-Grind welds flush as per Dwg D2750

→ CF 12-4-3

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube LH

Stop

NS2

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

7/6 12.4.3

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

QC7

1 SAD 12-04-03
PTO

Dart Aerospace Ltd

W/O: 82005		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-04-03	156	change Qc3 to Qc7 Done <i>[Signature]</i>					<i>[Signature]</i>

Part No: D 350-636-011 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

0.00

160

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI015

A/R Sikaflex-291

batch: M120813
exp. date: 12-8-13

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)

A/R Aluminum Rod

batch: M120164

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

BB 12/04/03

BE 12-4-3

BE 12/04/04

BB/MG 12-4-9

Dart Aerospace Ltd

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N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidube JH

Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

Handwritten: 1/CC 12/4/9

Handwritten: 8/12/4/10

Handwritten: 8/12/4/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Start Date: 21/03/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

1

Customer:

Reference:

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Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00				1X	0		m.f. 12/04/11
190									
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1X	0		m.f. 12/04/11
200									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:00 OVEN TEMPERATURE: 320°F FINISH TIME: 9:30								
210	QC Inspect Chemical Conversion Coat	0.00				1 htl	0		m 12/04/11
210									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

Dart Aerospace Ltd

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N9000040100

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Stop ***NS2***

Item Name: Skidtube LH

Start Date: 21/03/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00 ***1***

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

0.00

220

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

✓ 1- Install inserts as per Dwg D2750

1 htl d 21/04/12

230

0.00

230

HandFinishing

HandFinish

Memo

0.00

Hand Finishing

— 1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: 1014

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 11121221

EXP DATE: 12/01

4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube

✓ A/R 55-o-ring lube batch: 11110318

5-Coat all exposed fasteners with "LPS Procyon" batch: 11114596

1 htl d 21/04/12

Dart Aerospace Ltd

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Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 1.00

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

Dart Aerospace Ltd

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Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

12/4/23
12-04-20

Dart Aerospace Ltd

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Picklist Print

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ
 IPP Rev:J 06-03-23 As per Rev D JLM
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC
 IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec
 IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010
 DD verf:EC IPP Rev:P 10.06.22 revise
 seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH
 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3492-1		Manufactured	No			230	Each	106.0000	8	8			
									**	B81963 (x8) M1210419			
D3492-1													
Plug													

Location	Loc Qty	Loc Code
FP002	106	
69531	8	
74444	2	
76235	4	
77037	92	

D3492-3		Manufactured	No			230	Each	45.0000	8	8			
									**	B81967 (x8) M1210419			
D3492-3													
Plug													

Location	Loc Qty	Loc Code
FP-A	45	
78600	45	

Dart Aerospace Ltd

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Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

185.0000

8

8

NAS1611-010

O-RING

**

21 12/04/12

Location

Loc Qty

Loc Code

FP

50

110915

0

120770

50

FP001

135

110915

14

117460

8

118077

1

118612

3

119438

47

120308

12

120986

50

NAS1149D0863J

Purchased

No

250

Each

227.0000

2

2

NAS1149D0863.J

WASHER

**

2 13

Location

Loc Qty

Loc Code

ST298

227

118078

36

119307

91

120308

100

119307

D2744

Manufactured

No

110

Each

56.0000

1

1

D2744

Cap

**

BE 12/04/02

Location

Loc Qty

Loc Code

LG002

56

62715

1

70881

9

71861

4

78900

42

March-21-12 3:43:19 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D2600-3-BENT

Manufactured No

110

Each

17.0000

1

1

D2600-3-BFNT

Extrusion Bent

**

1

BB 12/04/02 *

Location

Loc Qty

Loc Code

LG

82347

17

66875

7

73253

1

75021

1

75022

1

75023

1

81330

6

D2743

Manufactured No

160

Each

216.0000

8

8

D2743

Crossbolt Spacer

**

BB 12/04/04

Location

Loc Qty

Loc Code

LG001

216

67766

4

68251

3

73403

64

74445

1

78603

44

79517

100

8

D2739

Manufactured No

160

Each

3.0000

1

1

D2739

350 I Beam

**

Location

Loc Qty

Loc Code

LG

81054

3

72155

1

80083

2

1

2/6 1243

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-3 Manufactured No

160 Each 22.0000 4 4

D3490-3

Cross Bolt Spacer

*BE 12/04/04
B 82016 *4*

Location

Loc Qty

Loc Code

LG001

22

78800

22

D3490-1 Manufactured No

160 Each 33.0000 4 4

D3490-1

Cross Bolt Spacer

*BE 12/04/04
B 81976 *4*

Location

Loc Qty

Loc Code

LG001

33

62450

2

74875

4

77042

3

78793

24

ALS4-1032-225 Purchased No

220 Each 980.0000 38 38

AI S4-1032-225

Insert

1112269 (x38) Huber

Location

Loc Qty

Loc Code

ST281

947

108696

146

110768

62

118386

55

118966

68

120671

616

ST282

33

120410

20

120451

13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

24.0000

1

1

D3793-3

Wearshoe

**

D82166 (x1) M nlo4119

Location

Loc Qty

Loc Code

FP001

12

80434

12

FP002

12

78935

12

AN8C35A

Purchased

No

230

Each

62.0000

1

1

AN8C35A

BOLT

**

M nlo4119

Location

Loc Qty

Loc Code

FP002

61

115960

1

117834

8

118286

52

ST346

1

114442

0

115188

0

115960

1

D3793-1

Manufactured

No

230

Each

16.0000

1

1

D3793-1

Wearshoe

**

M nlo4119

Location

Loc Qty

Loc Code

FP001

16

77029

4

78901

12

X1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 6

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3488-041

Manufactured No

230

Each

15.0000

1

1

D3488-041

Blade Fitting Assembly, LH

**

12/04/12

Location

Loc Qty

Loc Code

FP002

15

61689

1

75056

6

77021

8

D3794-3

Manufactured No

230

Each

29.0000

1

1

D3794-3

Gasket

**

12/04/12

Location

Loc Qty

Loc Code

FP002

29

74530

2

78895

3

80436

24

AN6C44A

Purchased No

230

Each

95.0000

4

4

AN6C44A

BOLT

**

11/20/12 (x4) 12/04/12

Location

Loc Qty

Loc Code

FG

2

103964

2

ST343

93

120143

25

120465

27

120641

21

121013

20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 7

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

79.0000

1

1

MS21083C8

NUT

**

12/04/12

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

X1

D3536-25

Manufactured

No

230

Each

14.0000

1

1

D3536-25

Gasket

**

381342 (x1) 12/04/12

Location

Loc Qty

Loc Code

FP002

14

78902

14

D3631-1

Manufactured

No

230

Each

191.0000

8

8

D3631-1

Washer

**

12/04/12

Location

Loc Qty

Loc Code

ST072

191

68062

2

75548

189

X2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1 Manufactured No

230

Each

15.0000

1

1

D3791-1

Wearplate

**

1382168 (x1) ul nlo4/c

Location

Loc Qty

Loc Code

FP002

15

62239

2

75041

1

78897

12

AN960C10L

NAS1149C0332

Purchased

No

230

Each

0.0000

38

38

*AN960C10I *

washer

D2745

Manufactured

No

230

Each

112.0000

8

8

D2745

Bushing

**

11121255 (x38) ul nlo4/c

**

381964 (x8) ul nlo4/c

Location

Loc Qty

Loc Code

FP

100

79518

100

FP001

12

69529

1

76142

1

78597

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:20 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,338.000

34

34

AN3C5A

Bolt

**

11 12/04/12

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1331

116419

28

117343

13

117764

7

117872

2

119749

23

120423

758

1210168

500

134

D3537-1

Manufactured

No

230

Each

87.0000

3

3

D3537-1

Wearpad

**

1373716 (x3) 11/12/04/12

Location

Loc Qty

Loc Code

FP001

82

79833

28

79835

54

FP002

5

69817

5

NAS1149C0832R

Purchased

No

230

Each

301.0000

1

1

NAS1149C0832R

WASHER

**

11 12/04/12

Location

Loc Qty

Loc Code

ST297

301

114915

301

11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:21 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C6A

Purchased

No

230

Each

571.0000

4

4

AN3C6A

BOLT

**

HL 12/04/19

Location

Loc Qty

Loc Code

FP001

1

111982

1

ST351

570

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

81

120693

400

X4

NAS1611-013

Purchased

No

230

Each

144.0000

8

8

NAS1611-013

O-RING

**

HL 12/04/19

Location

Loc Qty

Loc Code

FP001

144

116582

5

117291

2

117887

53

119623

36

120910

48

X 8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:21 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230

Each

17.0000

1

1

D3535-25

Wearshoe

**

Handwritten: 12/04/12

Location

Loc Qty

Loc Code

FP001

14

62233

1

80331

13

FP002

3

77617

3

D3794-1

Manufactured No

230

Each

22.0000

1

1

D3794-1

Gasket

**

Handwritten: 12/04/12

Location

Loc Qty

Loc Code

FP002

22

75042

10

80435

12

MS21043-6

Purchased No

230

Each

797.0000

4

4

MS21043-6

NUT

**

Handwritten: 12/04/12

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

777

112314

71

117887

6

118384

200

120308

500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-21-12 3:43:21 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

62.0000

2

2

**

D3493-1

Washer

Location

Loc Qty

Loc Code

ST050

62

70697

2

77573

20

78835

40

78835

MS21083C8

Purchased

No

250

Each

79.0000

2

2

**

MS21083C8

NUT

Location

Loc Qty

Loc Code

FP002

1

115884

1

ST303

12

115884

0

118077

1

119309

2

119436

7

119638

2

ST304

66

120142

16

120731

25

121011

25

121011

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 13

March-21-12 3:43:21 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased

No

250

Each

67.0000

2

2

✓

AN8C21A

BOLT

**

JB

Location

Loc Qty

Loc Code

ST343

67

118758

5

120094

38

120872

4

121067

20

120094

NAS1515H3L

Purchased

No

230

Each

172.0000

4

4

*NAS1515H3I *

WASHER

**

ul nlockig

Location

Loc Qty

Loc Code

FG

40

102472

40

ST277

132

118686

3

119438

1

120072

32

120360

96

X4

D2741

Manufactured

No

250

Each

33.0000

1

1

✓

D2741

Blade, 350 Skidtube

**

79516 JB 12/04/20

Location

Loc Qty

Loc Code

ST

-10

ST466

43

71856

1

76984

32

March-21-12 3:43:21 PM

Shop Packet Print

Page 13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 14

March-21-12 3:43:21 PM

Work Order ID: 82005

82005

Parent Item: D350-636-011

D350-636-011

Parent Item Name: Skidtube LH

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250

Each

39.0000

2

2

✓

D3532-1

Spacer

**

JB

12/04/20

Location

Loc Qty

Loc Code

ST053

39

78839

39

78839

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1	1			D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1	1	1	1	D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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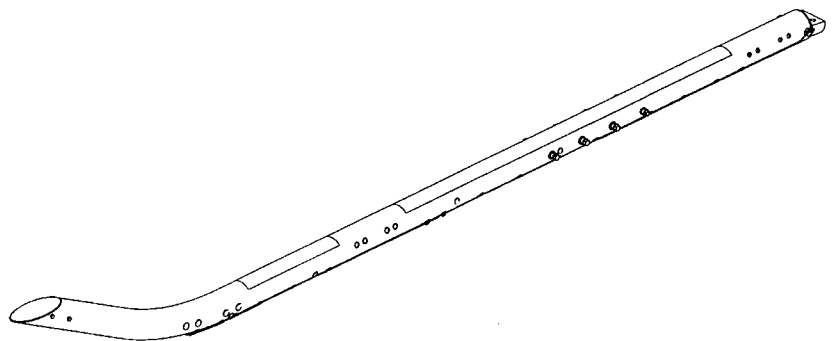
NO. 82005 MLJ

12/03/21

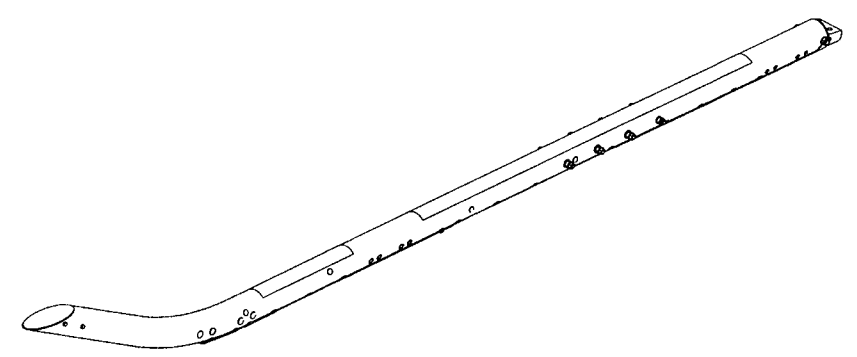
RELEASED

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 1 OF 11
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

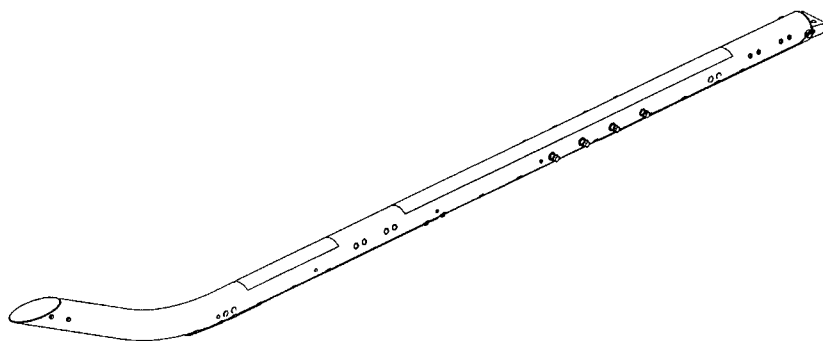


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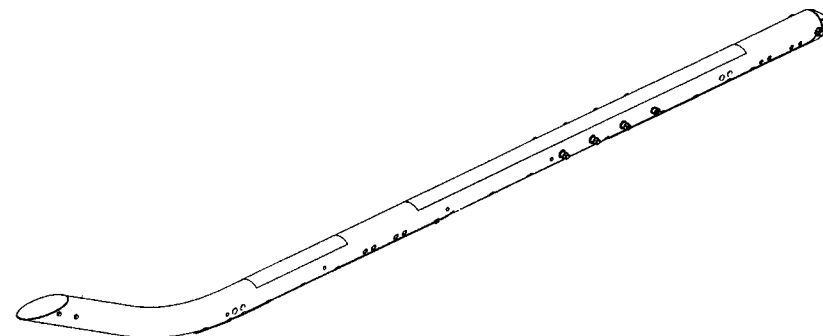
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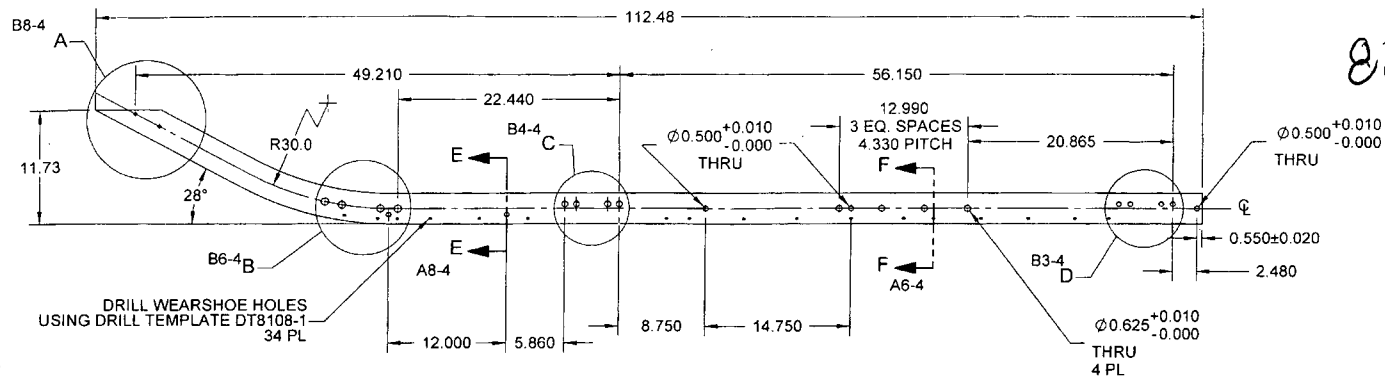
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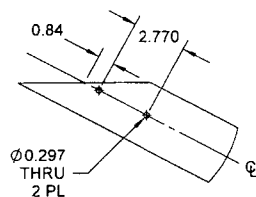
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68-09-22/1/11

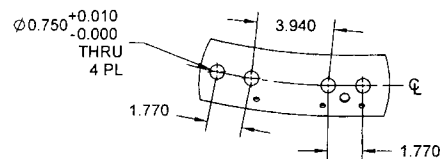
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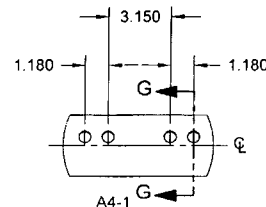
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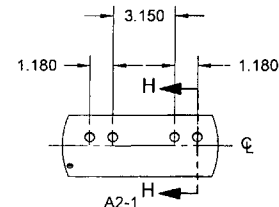
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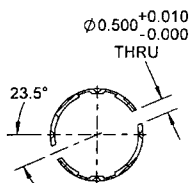
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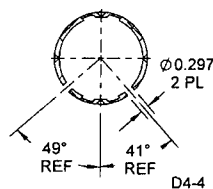
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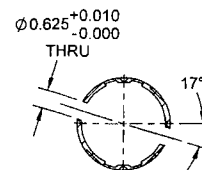
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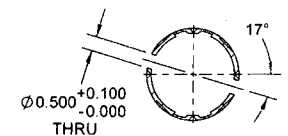
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL

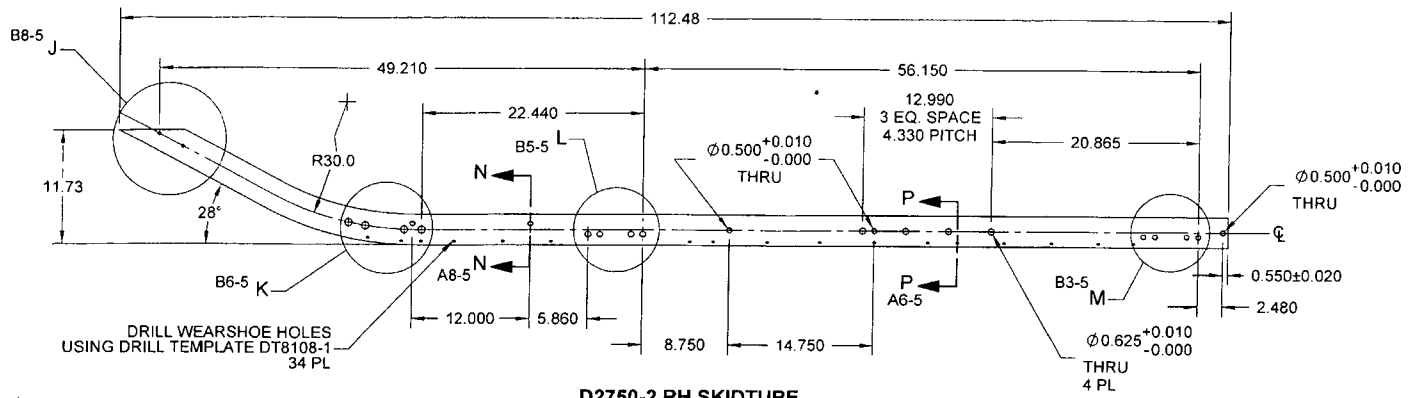


SECTION H-H
SCALE 3X, 4 PL

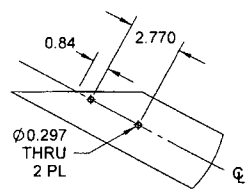
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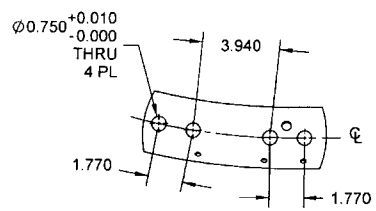
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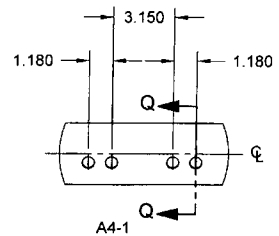
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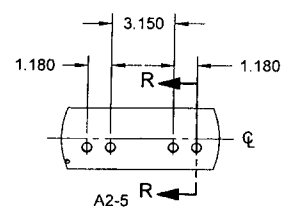
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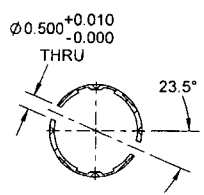
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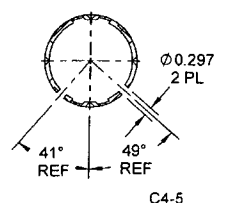
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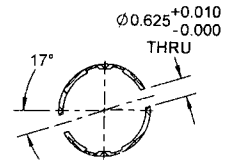
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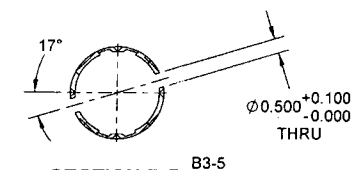
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



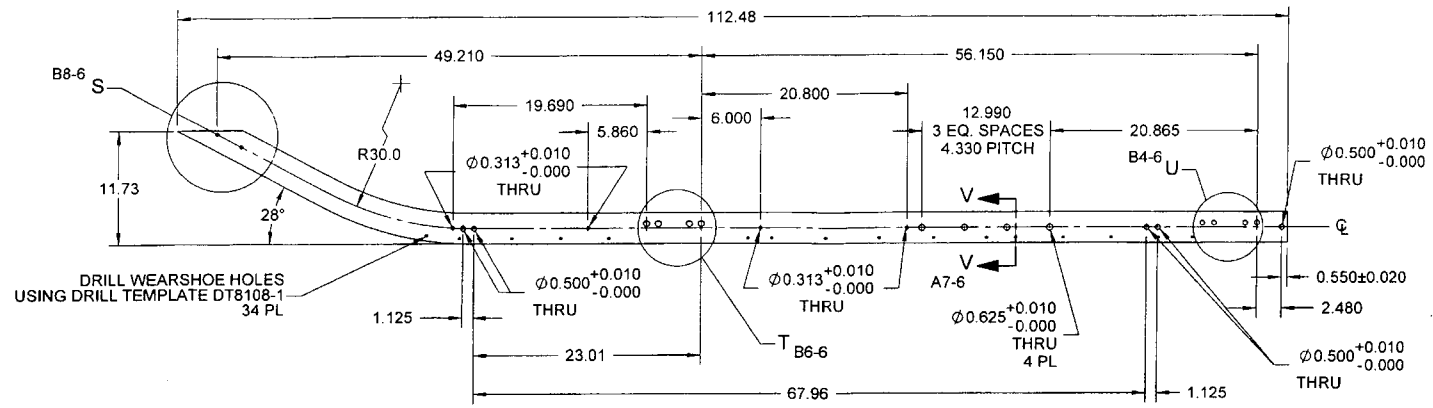
SECTION R-R
SCALE 3X, 4 PL

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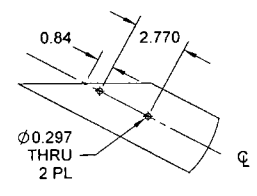
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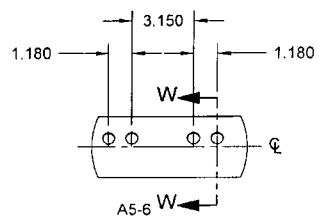
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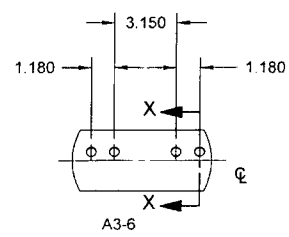
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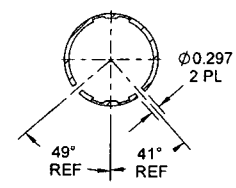
DETAIL S
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D8-6



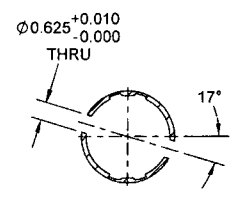
DETAIL T
SCALE 2X
C5-6
A5-6 W



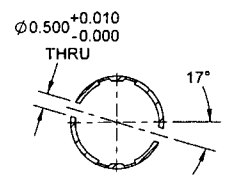
DETAIL U
SCALE 2X
D3-6
A3-6 X



SECTION V-V
SCALE 3X, 17 PL
C4-6



SECTION W-W
SCALE 3X, 4 PL
B6-6

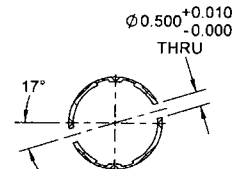
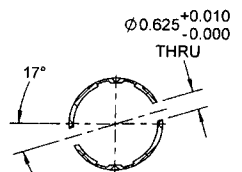
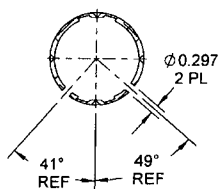
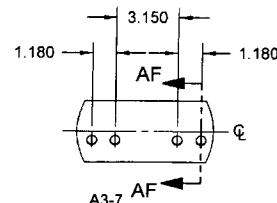
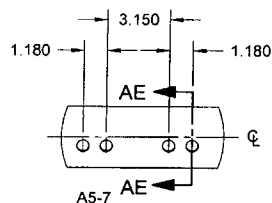
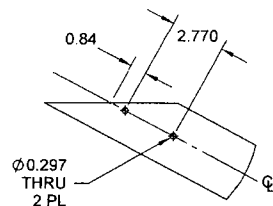
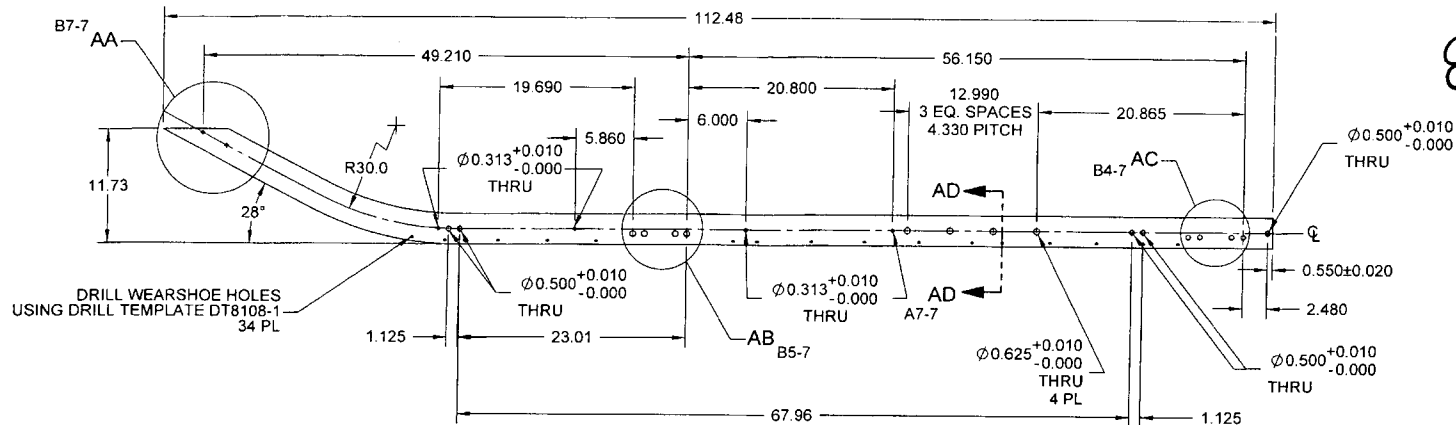


SECTION X-X
SCALE 3X, 4 PL
B4-6

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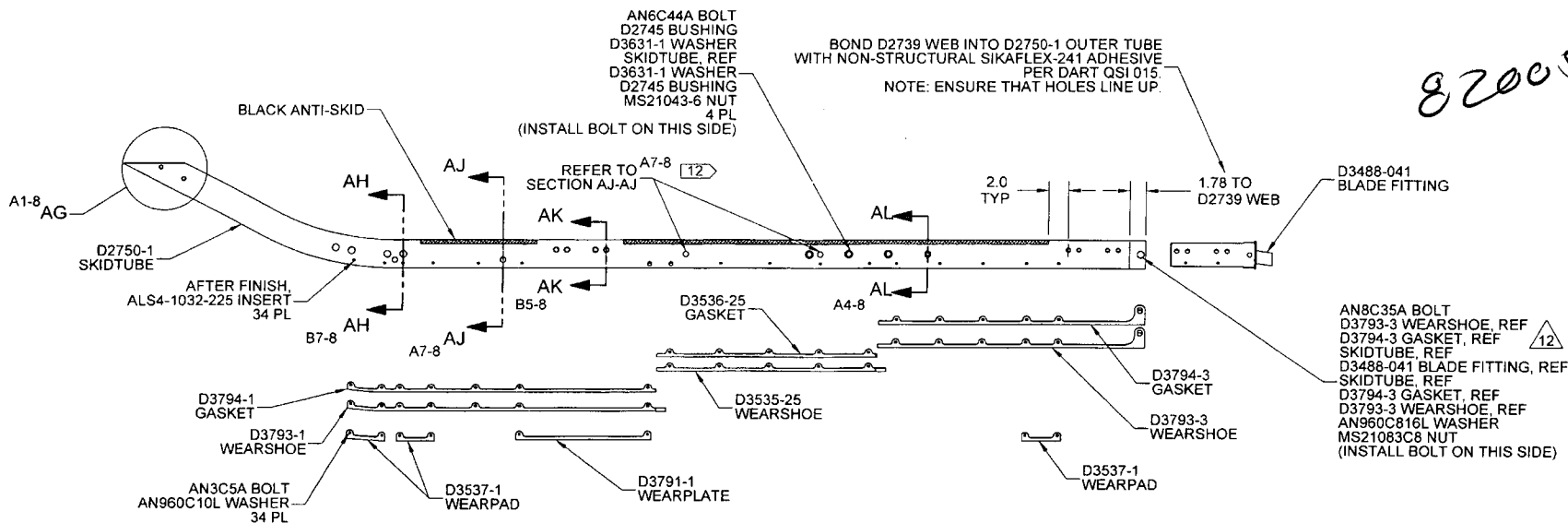


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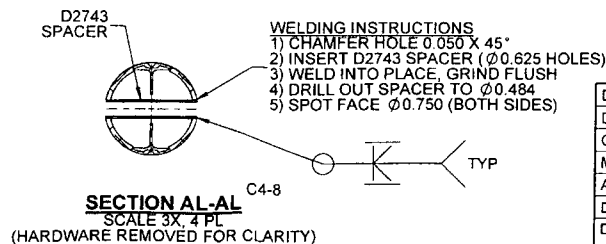
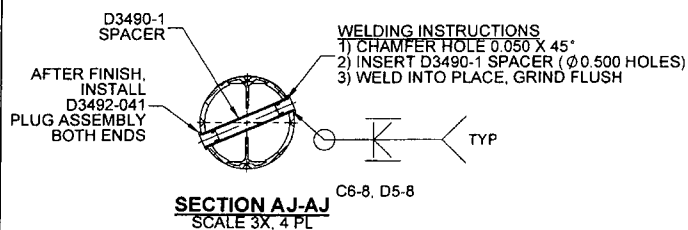
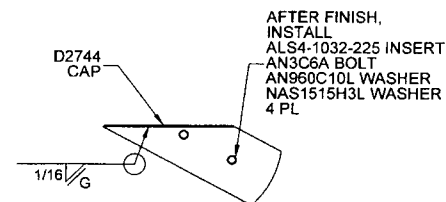
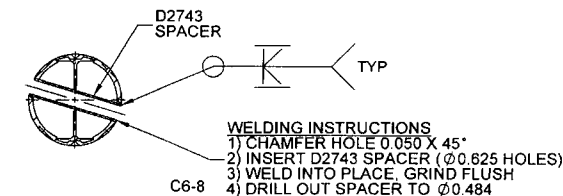
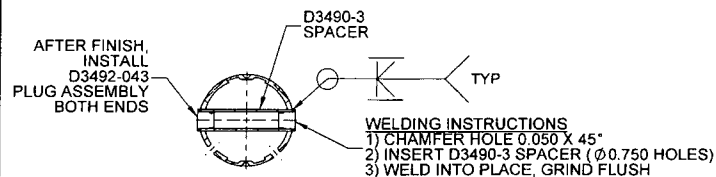
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

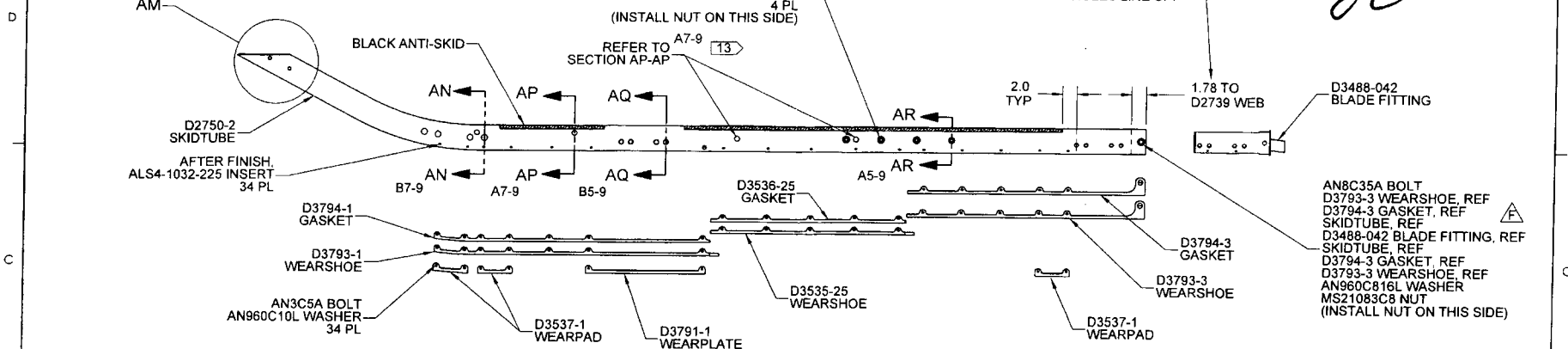


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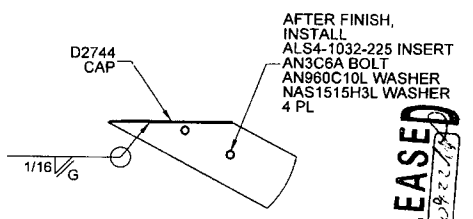
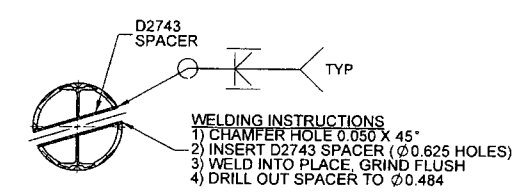
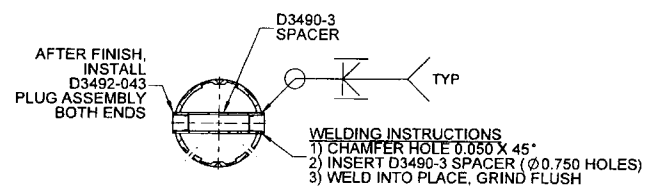
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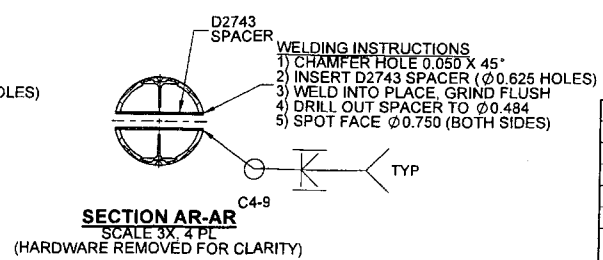
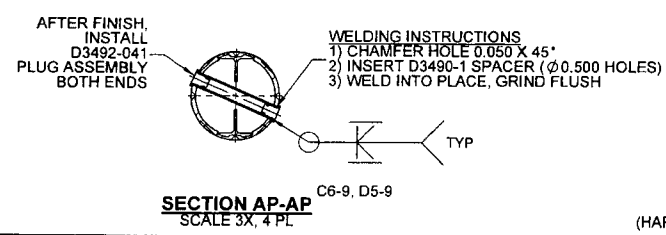
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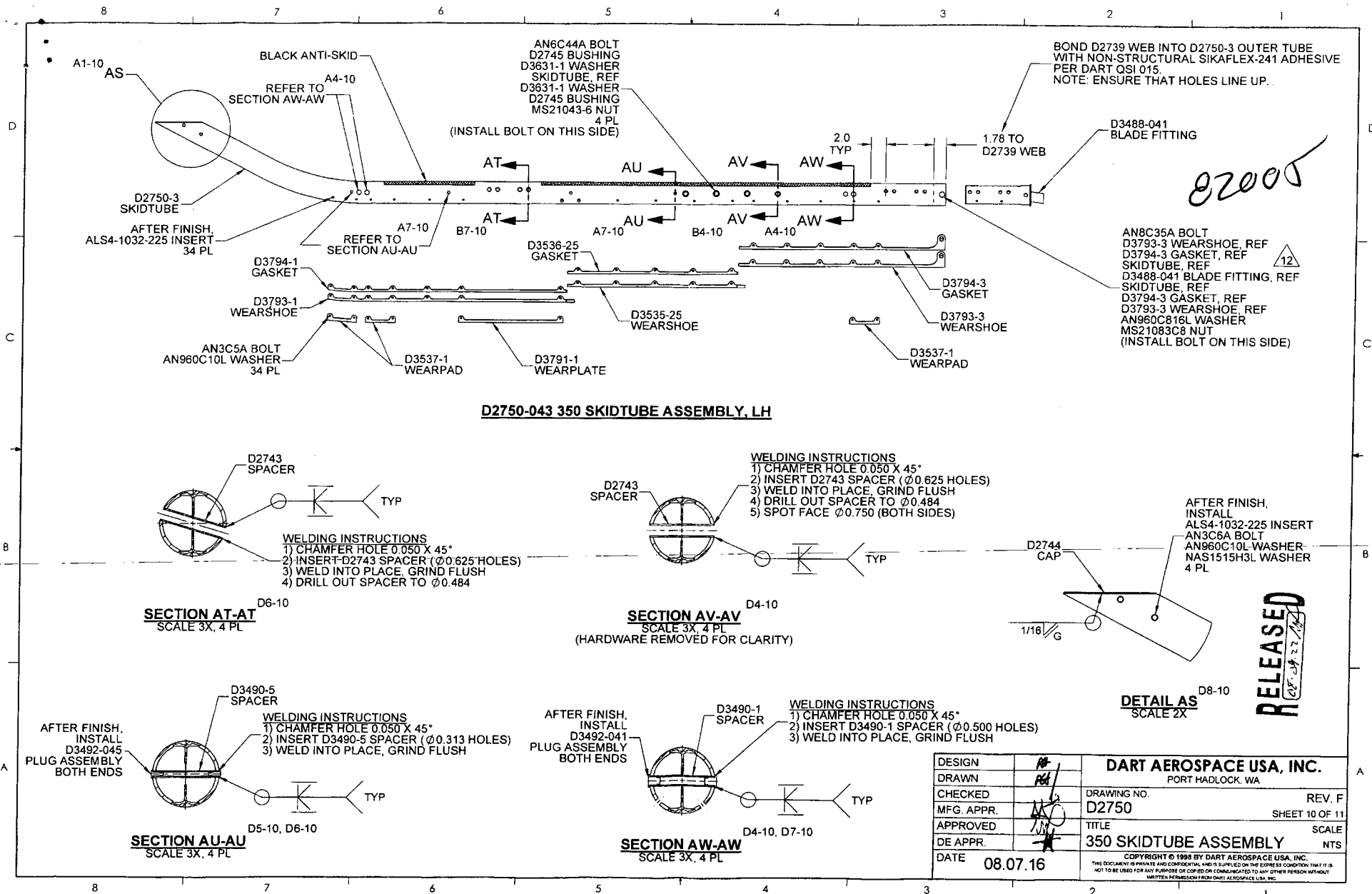
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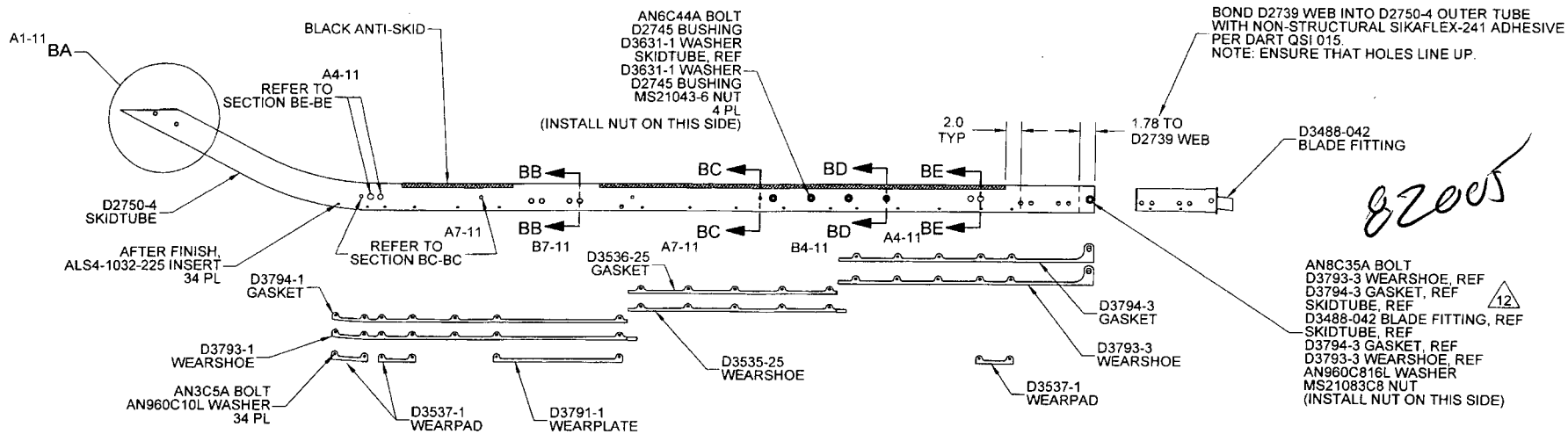
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08-09-2008



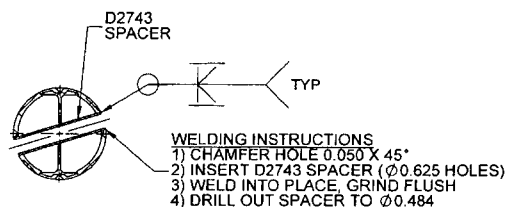
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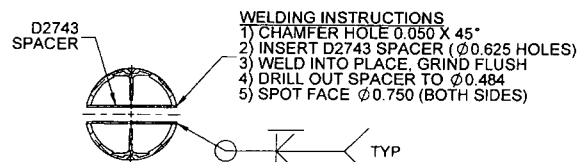
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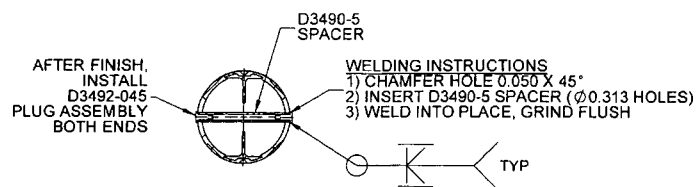
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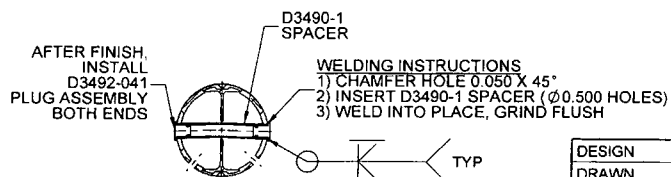
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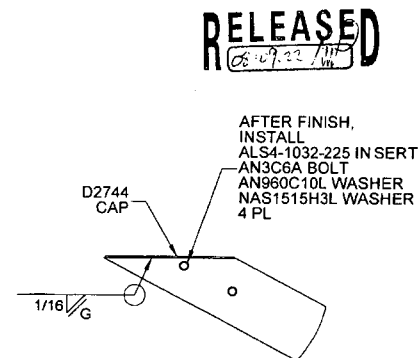
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(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL

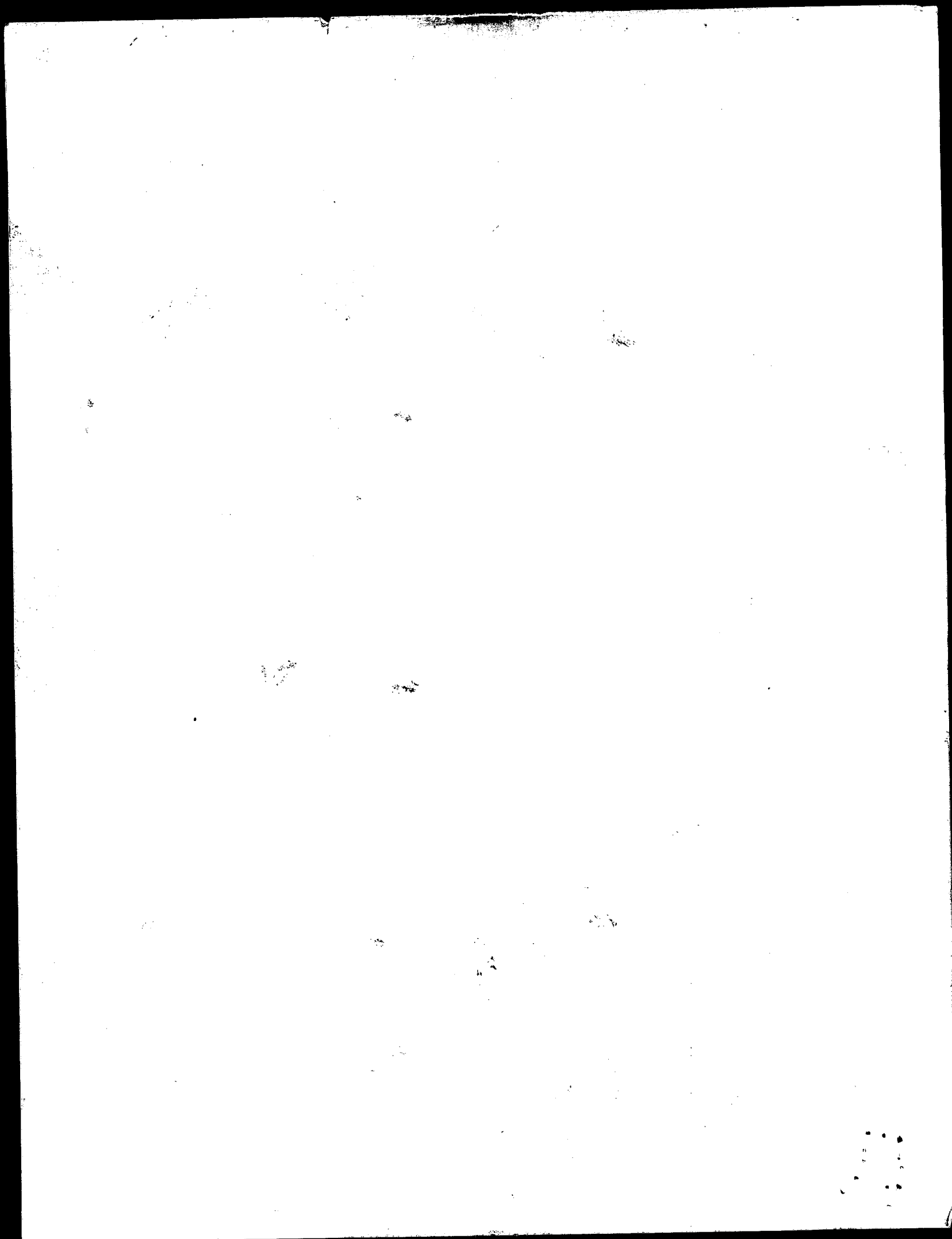


SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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NO. 286

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 82189
Part number: A350-606-012
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Lund Date of Test Coupon 12.04.03

Welder Barclay Elliott Date of Test Coupon 12-04-03

The above named individual is qualified in accordance with AWS D17.1.2001 to weld